

Work Order ID 83010

Thursday, April 12, 2012 11:31:19 AM

83010

Page 1

Item ID: D3778-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 4/12/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/20/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-04-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3778

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3778

Dwg Rev: B

6661.090

Prog Rev: B

****grain direction along 4.0" ****

2-Deburr if necessary

B12-4-12

(L3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

S. Z. 4/12

(A3)

130

Bend as per dwg

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

13

S

S
12/04/13

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

S. Z. 4/13

(A3)

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Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

(13) RLG 12-4-16

155

QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

13 6 BL 12-4-16

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-15 0.00

320 0 F

8-45

13 X 6 M-H 12/04/23

W117338

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

13 d 12/4/24

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

13 d 12/4/24

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/4/24 MF 12-04-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, April 12, 2012 11:31:18 AM

Page 1

Work Order ID: 83010

Parent Item: D3778-3

Parent Item Name: Bracket

Start Date: 4/12/2012

Required Date: 4/20/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-03-21 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased	No			100	sf	85.0000	0.1666	1.0522105	2.2		
6061-T6 .090 Sheet													

Location

Loc Qty

Loc Code

MAT021

85

109184

2

111382

83

B12-4-17

111382

(13)

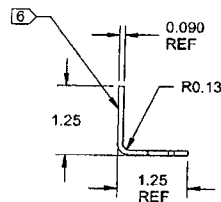
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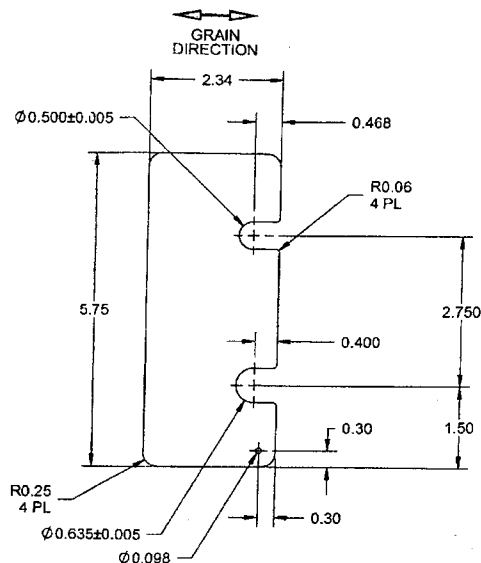
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D3778-1 BRACKET



D3778-1F FLAT PATTERN



83010

RELEASED
2012-03-31

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-X" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -1: 0.11 lbs
-3: 0.17 lbs

B	ADDED -3 (REF: PAR 12.-163)	AJS	12.03.15
A	NEW ISSUE	PH	08.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3778	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.03.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE FURTHER CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

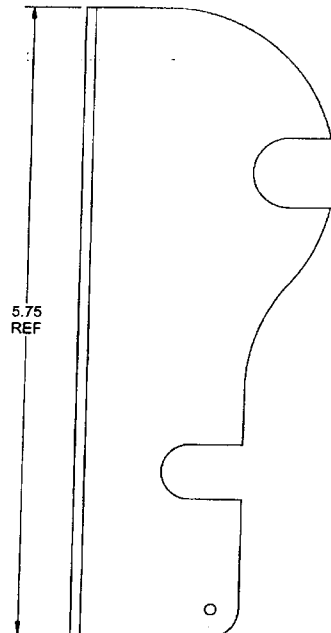
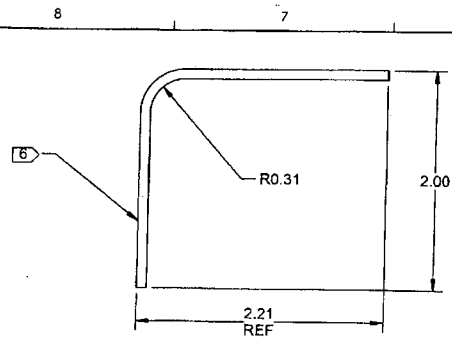
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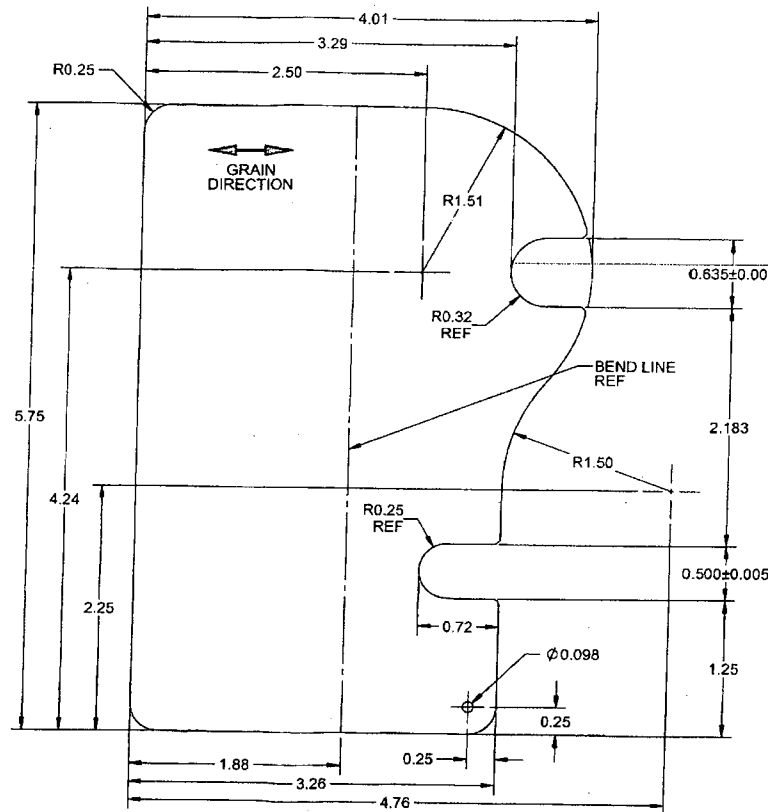
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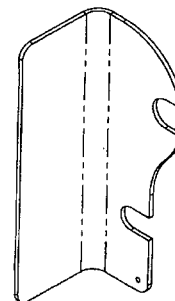
NOTE: Date & initial all entries



D3778-3 BRACKET



D3778-3F BRACKET
(FLAT PATTERN)



* 83010

RELEASED
2012-03-30

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3778	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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